

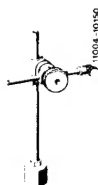
## 05—225 Grinding camshaft bearing journals

### Data

Roughness of camshaft bearing journals		0.003
Perm. runout of center bearing journal and camshaft sprocket seat when mounting camshaft at outer bearing journal		0.0125
Bearing points (Fig. )	a	b and c
Normal dimension	camshaft bearing dia.	$\frac{35.00}{35.02}$ $\frac{49.00}{49.02}$
	journal dia.	$\frac{34.95}{34.93}$ $\frac{48.95}{48.93}$
Intermediate stage	camshaft bearing dia. (color coding grey)	$\frac{34.90}{34.92}$ $\frac{48.90}{48.92}$
	journal dia.	$\frac{34.85}{34.83}$ $\frac{48.85}{48.83}$
Repair stage I	camshaft bearing dia. (color coding red)	$\frac{34.75}{34.77}$ $\frac{48.75}{48.77}$
	journal dia.	$\frac{34.70}{34.68}$ $\frac{48.70}{48.68}$
Width A of journal a (Fig.)	$\frac{34.00}{34.04}$	
Bearing play	radial	0.050—0.084
	axial	0.07—0.15

### Special tool

Dial gauge holder for end play of camshaft (2 each)



363 589 00 02 00

### Conventional tool

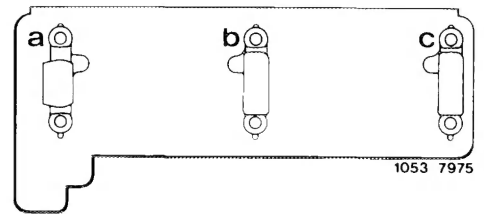
Dial gauge A 1 DIN 878

e.g. made by Mahr, D—7300 Esslingen  
order No. 810

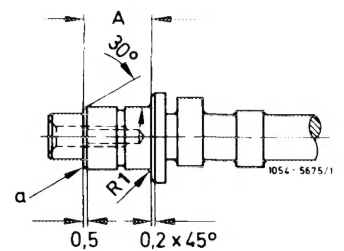
### Note

In the event of repairs, regrind camshaft in accordance with available camshaft bearings.

The camshaft bearing journals are not hardened.

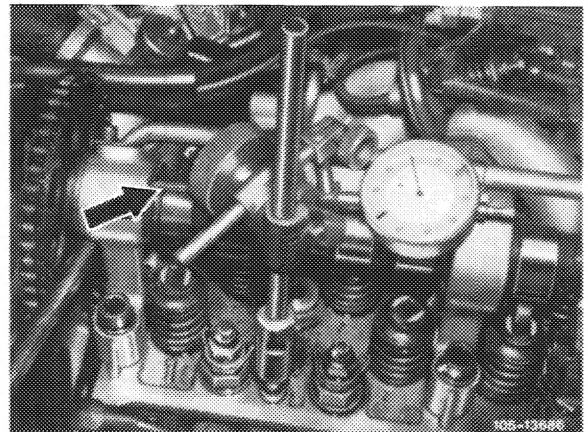


If dimension A is exceeded when grinding 1st bearing journal, also regrind face a.



### Measuring end play

- 1 Screw-on dial gauge holder with threaded sleeve at front left.
- 2 Position dial gauge at approx. 3 mm preload against thrust flange of camshaft (arrow).
- 3 Push camshaft toward the rear and set large needle to zero.



- 4 Push camshaft forward and determine end play.

**Note:** If the end play is too low, touch up 1st camshaft bearing at its face surfaces (arrow).

If the end play is too high, regrind face a on camshaft.

